

Work Order ID 62001

Wednesday, September 15, 2010 9:54:51 AM

Page 1

Item ID: D3183-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket Assembly

Start Date: 9/14/2010 Start Qty: 6.00

Required Date: 9/21/2010 Req'd Qty: 6.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *N*Date: *10-9-15*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3183	Rev C1
-------	--------

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (1.500" x 2.250") 5.500" long

SL 10/09/20

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3183-3 as per F6lio FA322 and Dwg D3183 Identify as D3183-3
3-Deburr-3-Scribe batch number*SL 10/09/24* *6*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 10/09/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Cust Item ID:

Required Date: 9/21/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

LF 10/07/25

6

0

140



Small Fab

Small Fab

Small Fab

Memo

Assemble D3183-043 as per Dwg D3183.

0.00

0.00

LF 10/10/06 (6)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/10/06

(x6)

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Page 3

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location *234*

0.00



Packaging

Memo

0.00

Packaging

10/10/06

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/10/06**MF*
10-10-06

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NOTE: Date & initial all entries

Picklist Print

Wednesday, September 15, 2010 9:54:55 AM

Page 1

Work Order ID: 62001

Parent Item: D3183-043

Parent Item Name: Bracket Assembly




Start Date: 9/14/2010

Required Date: 9/21/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:Pick:A 04.02.18 New issue KJ/DS
IPP Rev:B Changed Mat Size 08-06-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3183-045  Bearing Assembly		Manufactured	No			100	Each	22.0000	2	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST236		22							
				61642		2							
				61671		20							
D3121-21  Bolt		Manufactured	No			140	Each	55.0000	2	12			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST235		55							
				57376		1							
				60493		6							
				61648		48							
M174B1.500X02.250  17-4 SS Bar 1.50 X2.250		Purchased	No			140	f	16.4733	0.4583	2.894526			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT031		16.47326							
				108309		1							
				113568 X 2		15.47326							
				m174B2.000 x 01.500		113189 X 4							

ES 10/10/06
62216 (12)

ES 10/10/06
12

SL 10/09/20
1.93

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	62001
Description: Bracket		Part Number:	D3183-3
Inspection Dwg: D3183	Rev: C1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.190	+/-0.030	.190	✓		F-G	
R0.063	+/-0.010	.063	✓		"	
0.182	+/-0.010	.182	✓		VERN JL-3	
0.070	+/-0.010	.069	✓		"	
0.100	+/-0.010	.102	✓		"	
Ø0.201 x 0.100	+/-0.010	.196 x .103	✓		"	
0.182	+/-0.010	.181	✓		"	
5.32	+/-0.030	5.320	✓		"	
5.036	+/-0.010	5.034	✓		H-G	
2.120	+/-0.010	2.120	✓		"	
1.290	+/-0.010	1.290	✓		VERN JL-3	
0.365	+/-0.010	.365	✓		"	
0.218	+/-0.010	.218	✓		"	
1.030	+/-0.010	1.029	✓		"	
1.90	+/-0.030	1.899	✓		"	
1.012	+/-0.010	1.011	✓		"	
Ø0.201 x 0.100	+/-0.010	.201 x .103	✓		"	
0.786	+/-0.010	.788	✓		"	
Ø0.392	+0.002/-0.000	.392	✓		"	
R0.19	+/-0.030	.190	✓			
3.954	+/-0.010	3.957	✓		H-G	
0.162	+/-0.010	.162	✓		VERN JL-3	
R0.19	+/-0.030	.190	✓		R-G	
R0.25	+/-0.030	.250	✓		"	
4.26	+/-0.030	4.265	✓		VERN JL-3	
2.080	+/-0.030	2.08	✓		"	
1.155	+/-0.010	1.155	✓		"	
0.162	+/-0.010	.163	✓		"	
0.36	+/-0.030	.36	✓		"	
0.615	+/-0.010	.620	✓		"	
0.435	+/-0.010	.433	✓		"	
0.200	+/-0.010	.199	✓		"	
0.381	+/-0.010	.391	✓		"	
0.032	+/-0.010	.027	✓		D-G JL-7	

Measured by:	SL	Audited by:	LS	Prototype Approval:	N/A
Date:	10/09/20	Date:	10/09/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D3183-043	KJ/RF	
B	04.03.15	Changes as per revision C	KJ/JLM/RF	
C	06.03.09	Dwg Rev update	KJ/JLM	
D	08.01.28	0.182 dimension removed	KJEC/DD	

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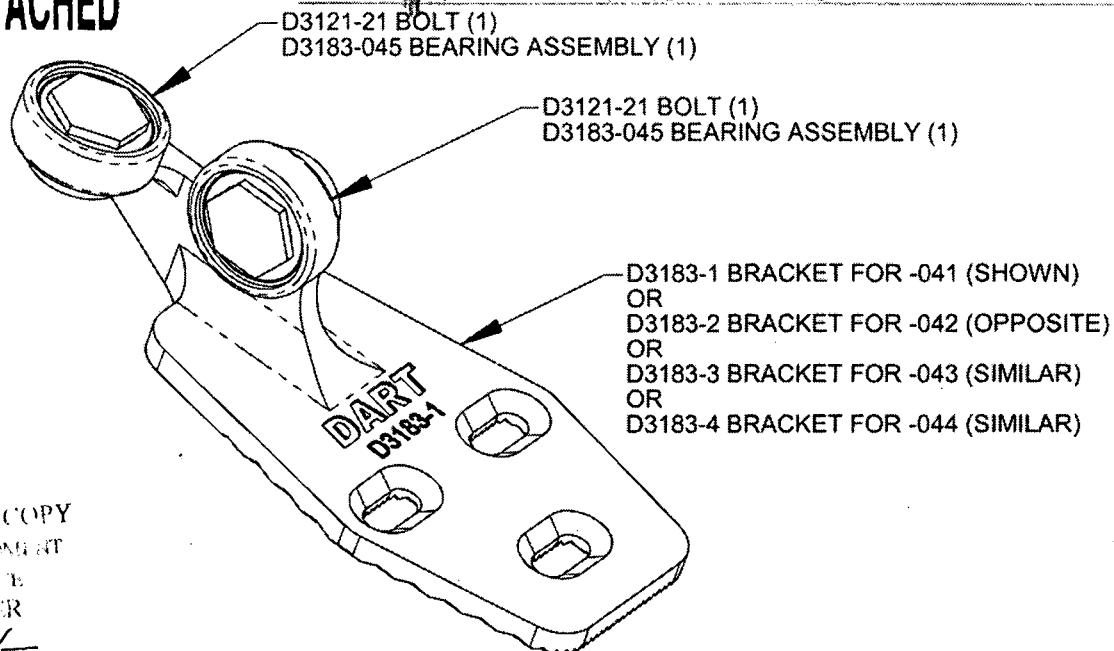
NOTE: Date & initial all entries



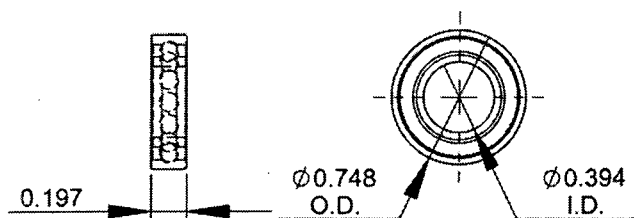
DESIGN #	DRAWN BY ip	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
CI	04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01
DEO ATTACHED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO REWORK
WORK ORDER
NO. **62001**
ps 10 9 15

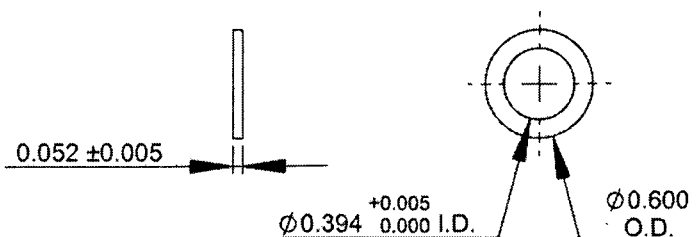


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

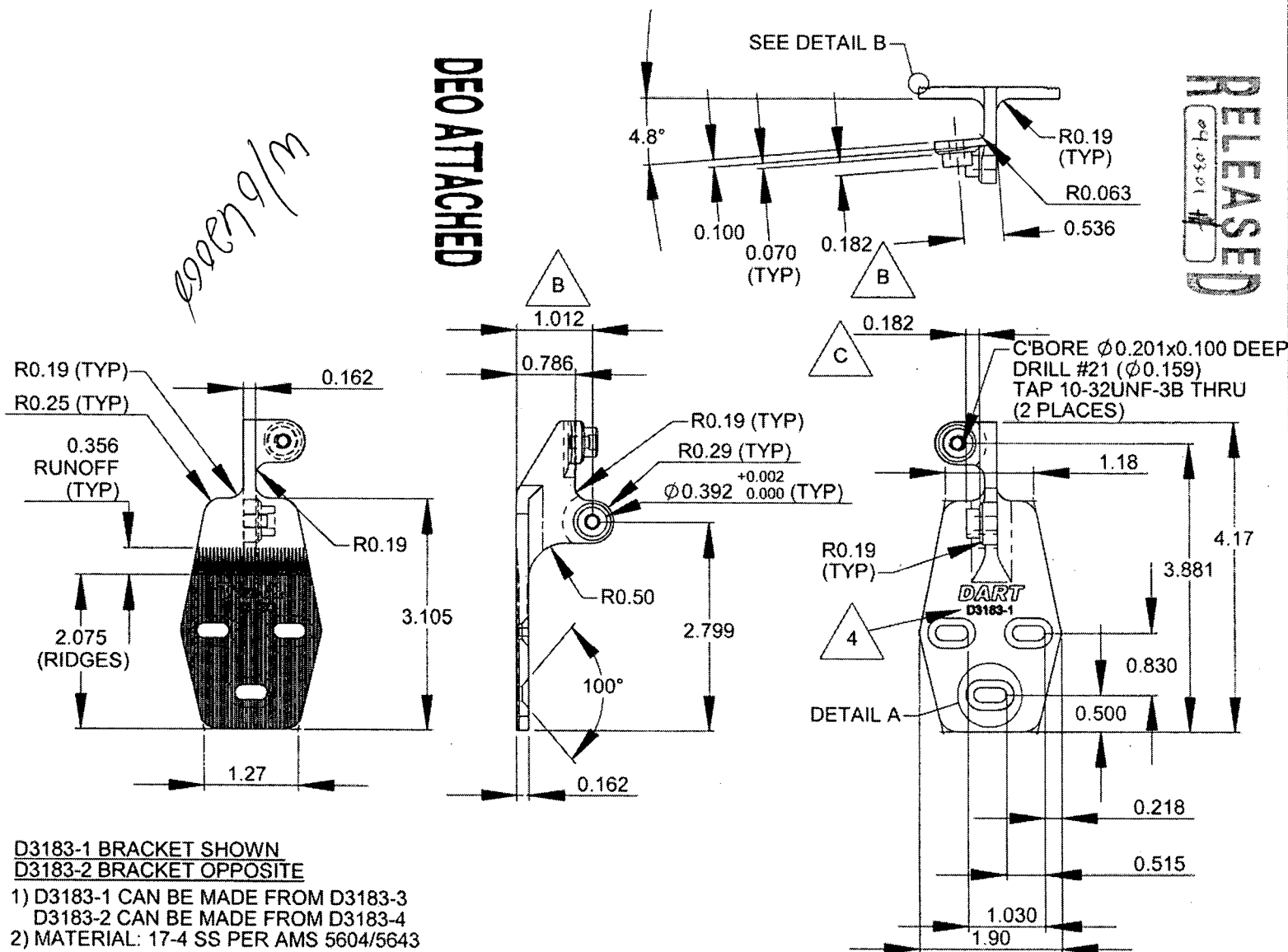
- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3183	REV. C
DATE 04.02.17	TITLE BRACKET ASSEMBLY	SHEET 2 OF 4	
		SCALE 1:2	

RELEASED
04.03.01**DEO ATTACHED**

D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

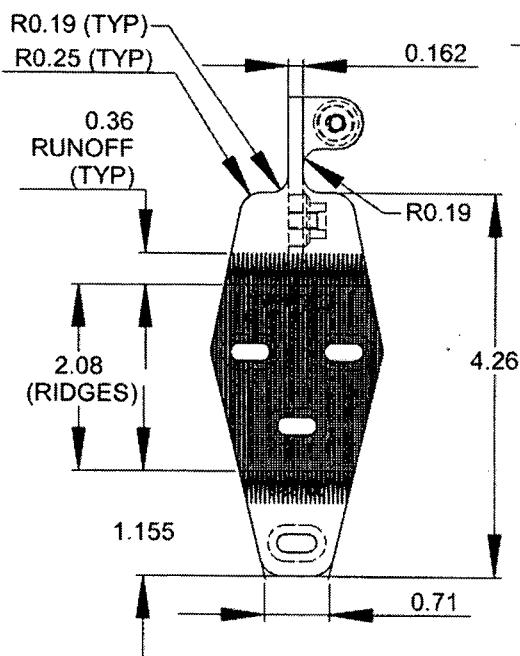
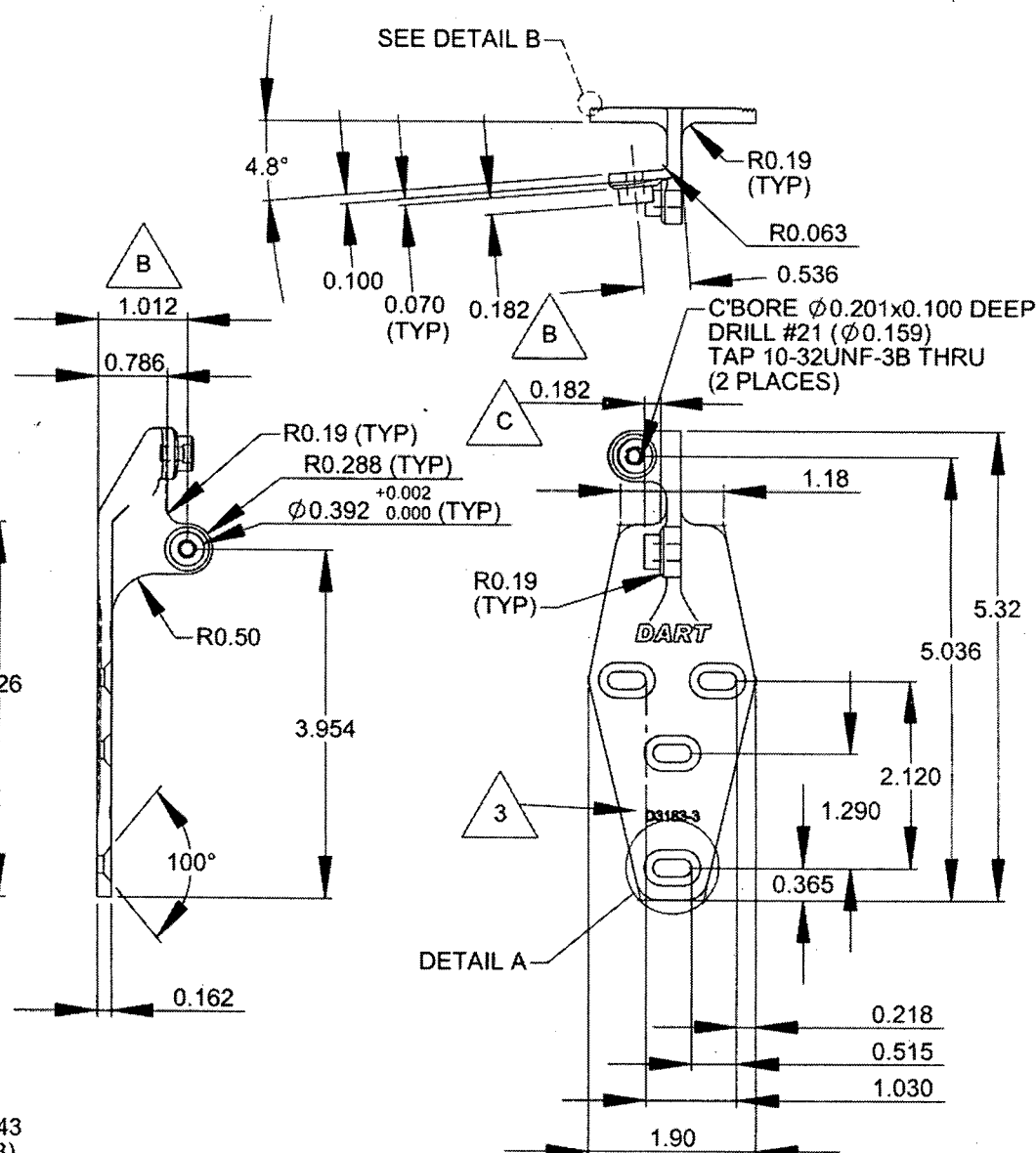
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NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE 04.02.17	DRAWING NO. D3183	REV. C
	TITLE BRACKET ASSEMBLY	SHEET 3 OF 4
		SCALE 1:2



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

w/o 42001

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DEO ATTACHED
RELEASED
04.03.01

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

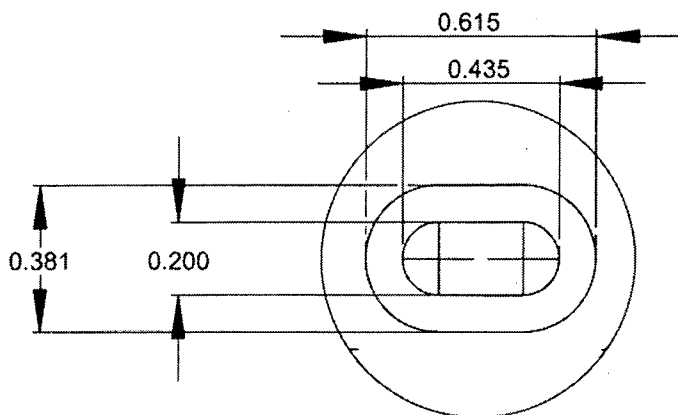
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 4 OF 4
DATE 04.02.17	TITLE BRACKET ASSEMBLY		SCALE 1:1

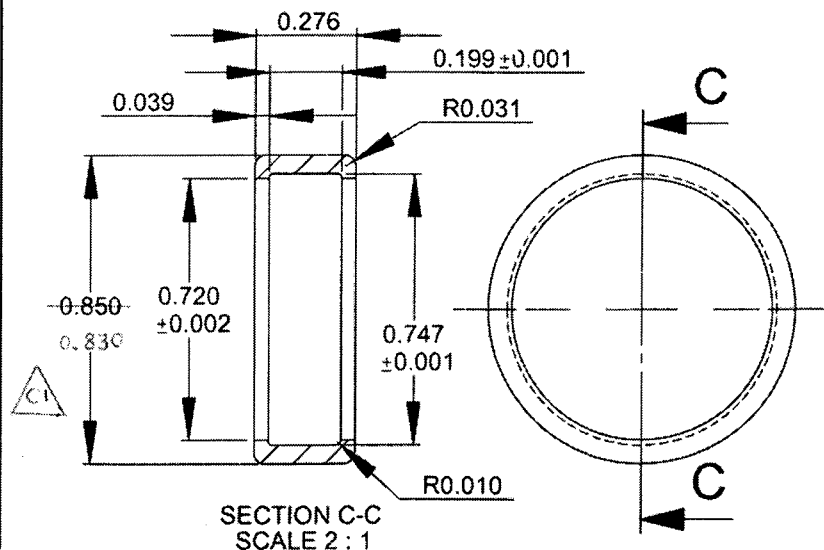
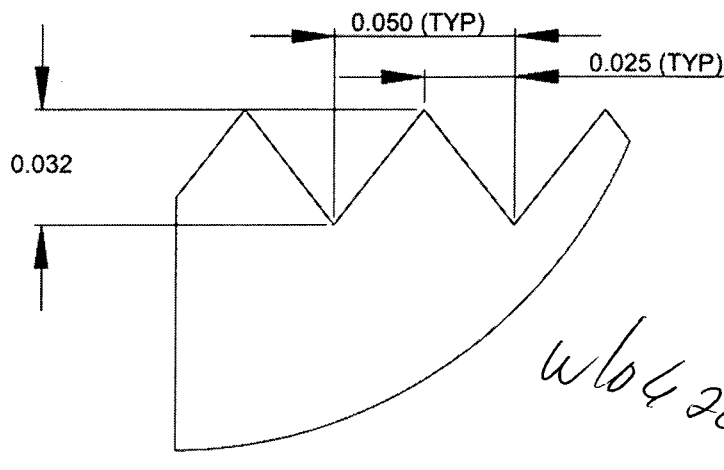


DETAIL A (2 : 1)

RELEASED
04.03.01

DEO ATTACHED

DETAIL B (20 : 1)



D3183-9 CAP

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP

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Dart Aerospace Ltd

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